

Fig. 1

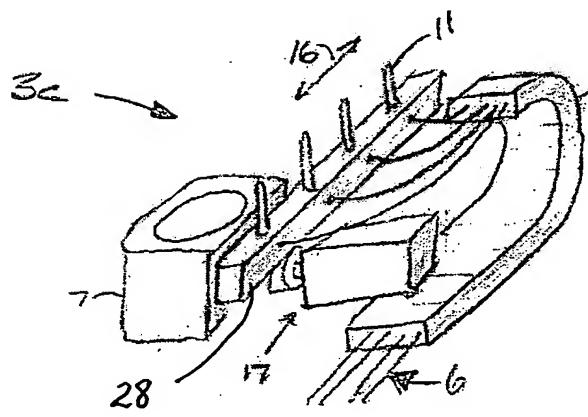


Fig. 4

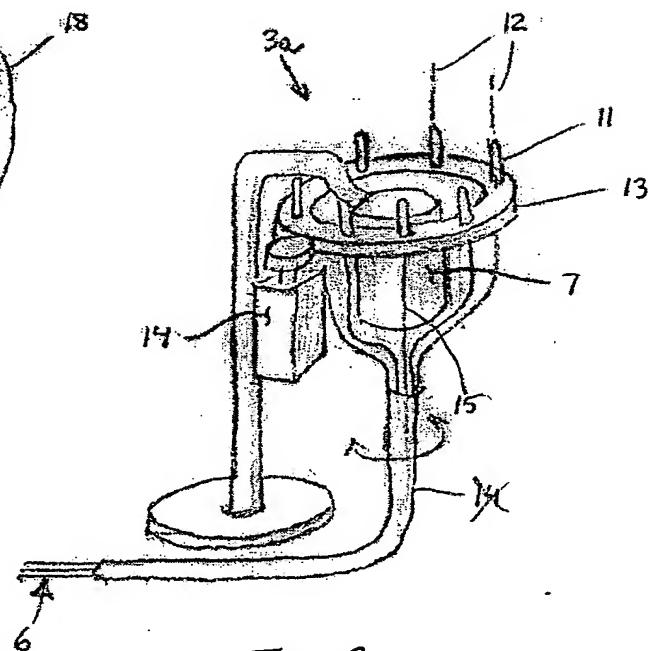


Fig. 2

Process step	Description	Valve state									Docking position	Piston position
		8	52	53	55	32	33	34	44	48		
A	Finished painting green										remote	at bottom
B	Clean piston face and bell cup, index injector	on	on		on		on	on	on		remote	oscillate near bottom
C	Dock with paint supply										docked	at bottom
D	Prime lines with red paint					on		on	on	docked	docked	at bottom
E	Fill canister with red paint					on		on	on	docked	docked	retracting
F	Leave dock & clean injector	on	on		on	on	on				near	at top
G	Clean control valve face	on	on	on							remote	at top
H	Paint with red								on / off		remote	dispense

Fig. 9

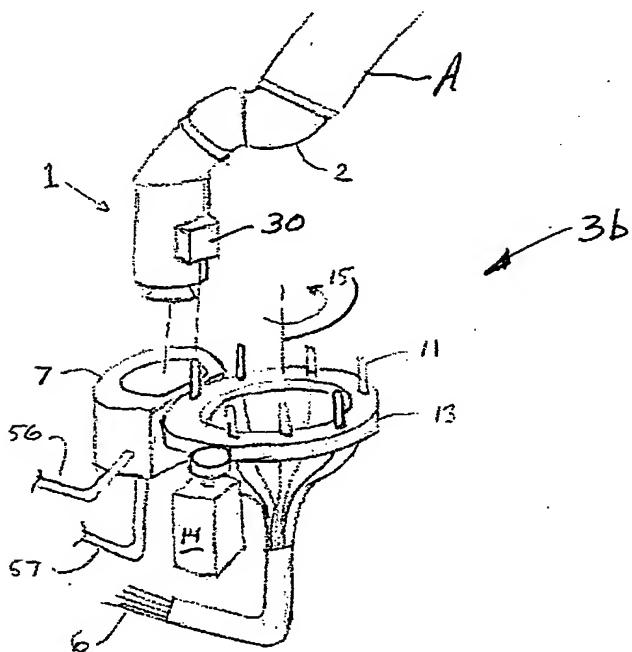


Fig. 3

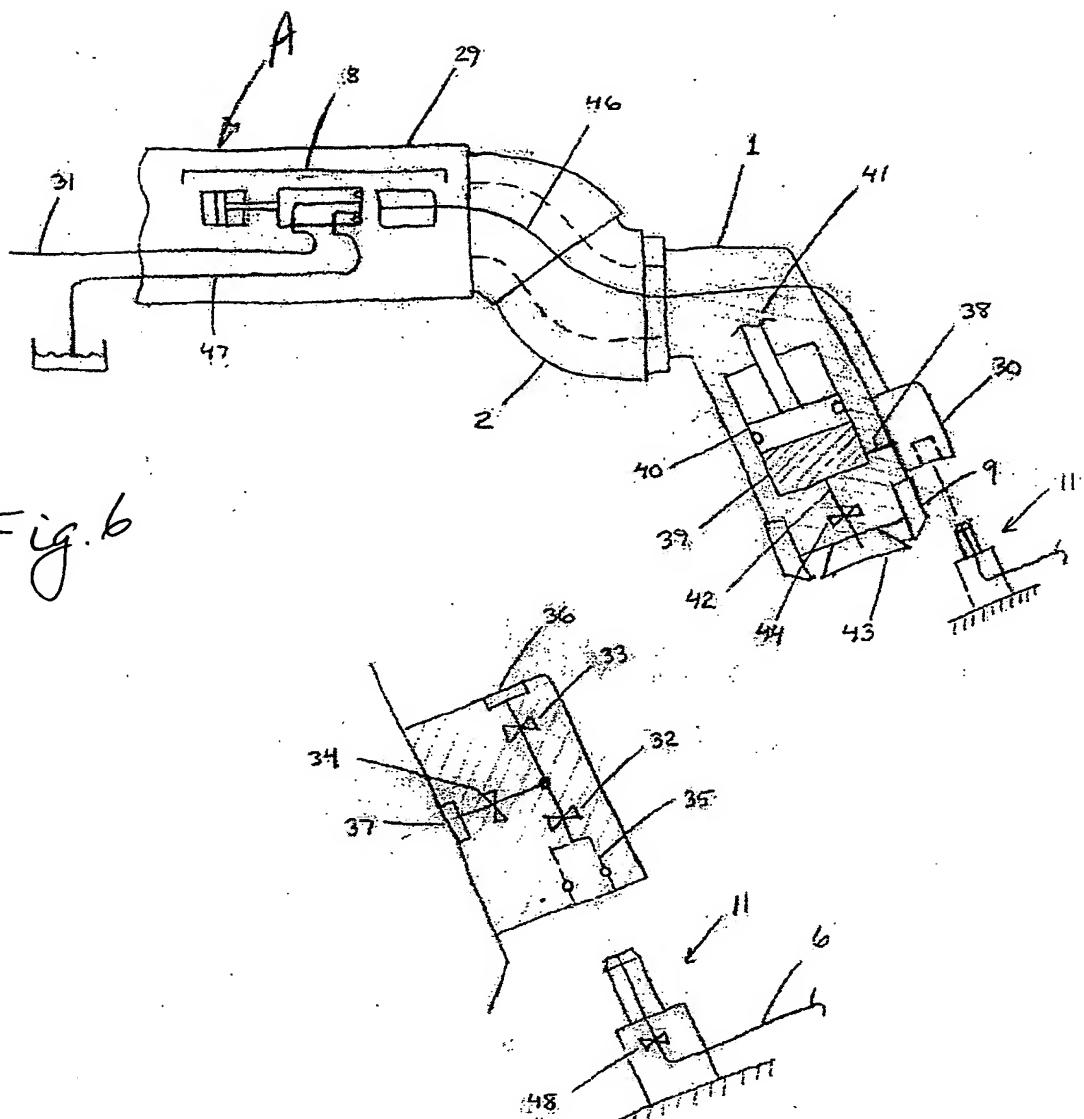


Fig. 5

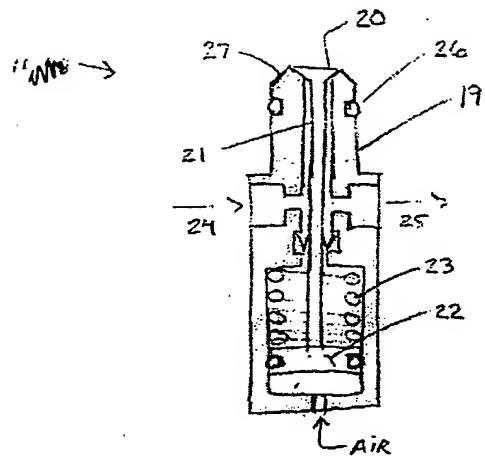


Fig. 7

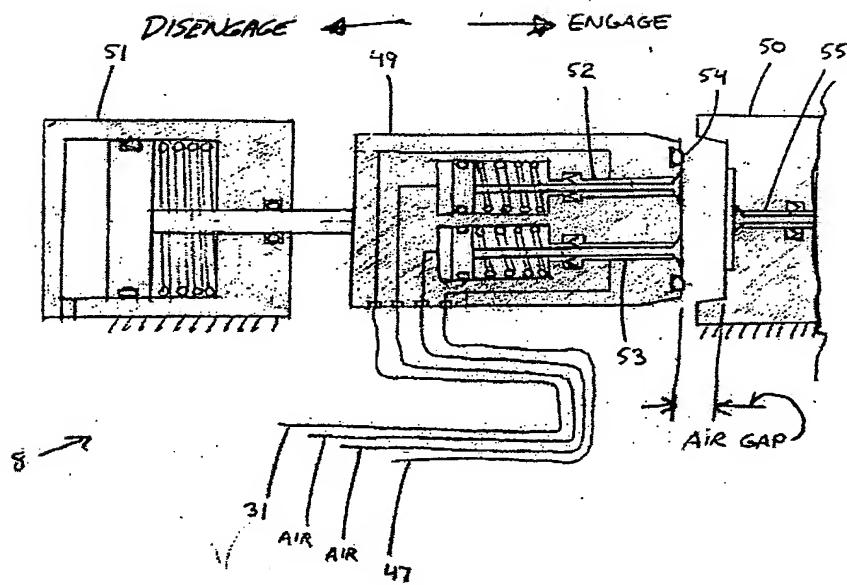
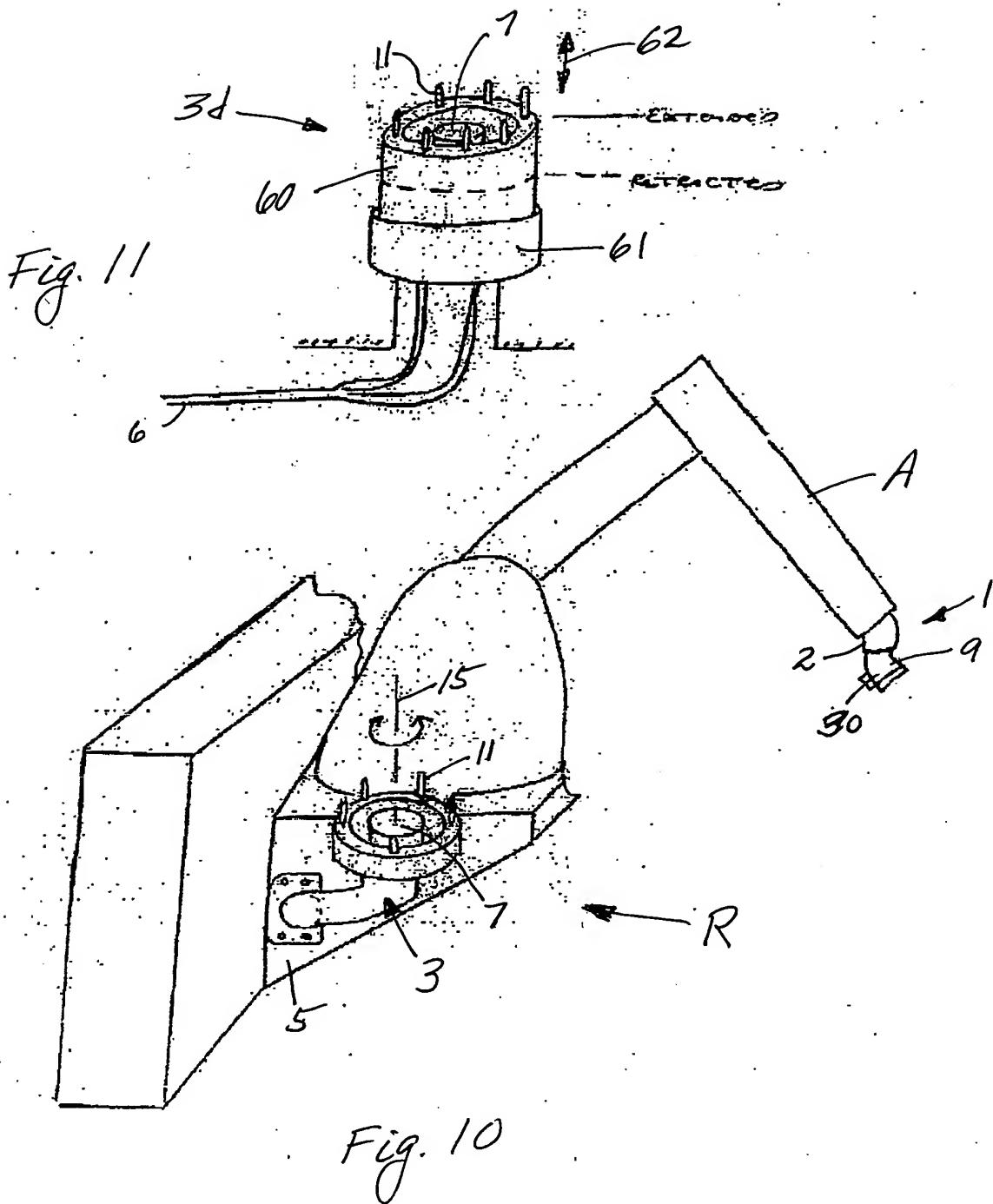
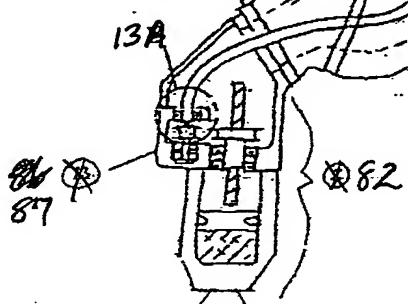
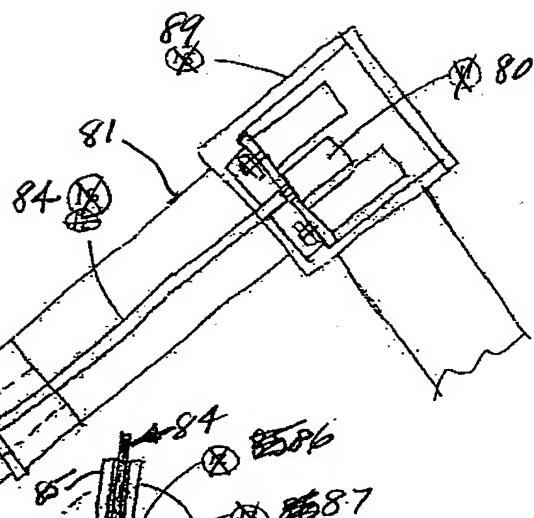
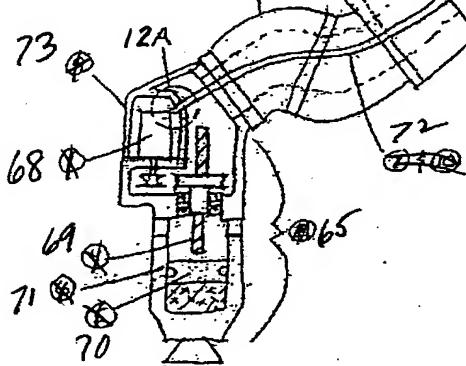
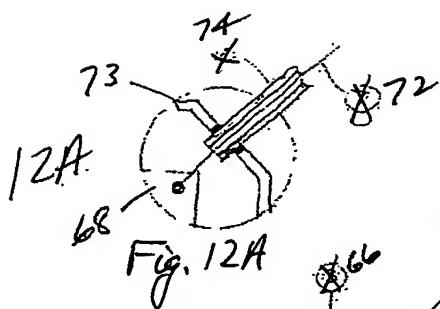


Fig. 8





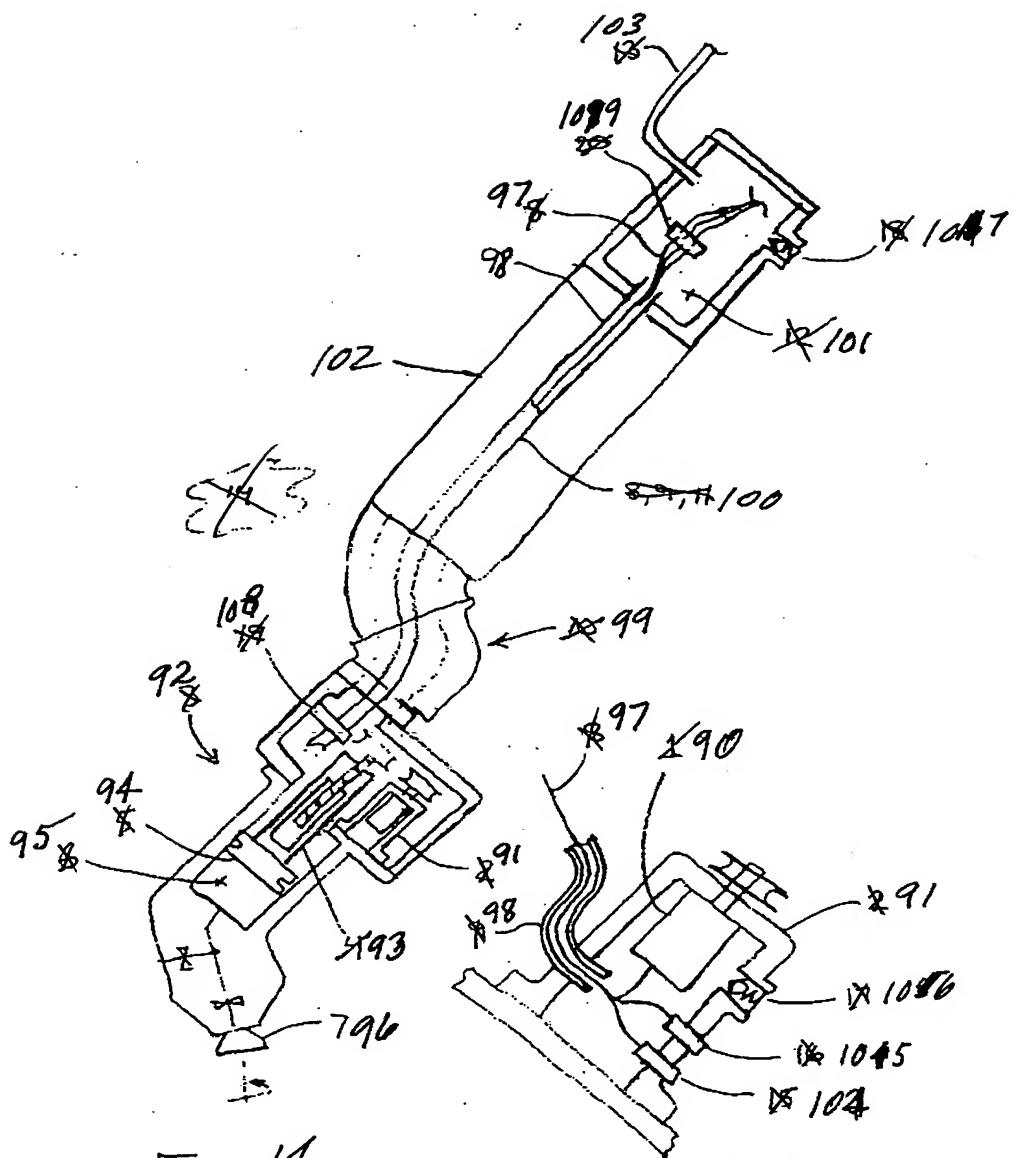


Fig. 14.

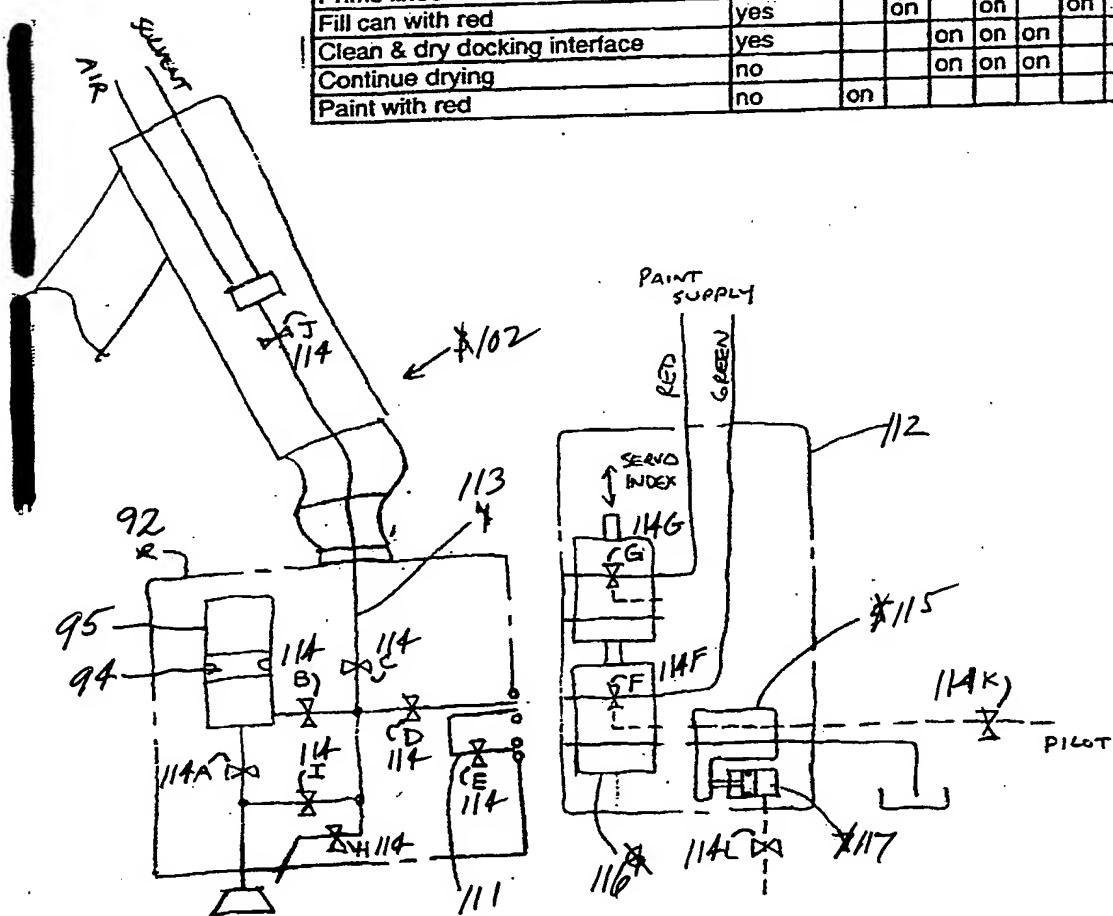
Fig. 15

*Fig. 17*

Process sequence - changing color	Docked	Valve											
		A	B	C	D	E	F	G	H	I	J	K	L
Done painting red	no												
Clean piston face & inside bell cup	no		on	on	on							on	
Clean outside of bell	yes/no				on					on		on	
Index to green supply	yes/no												
Clean shroud	yes												
Prime lines with green	yes	on	on		on		on						on
Fill can with green	yes		on		on		on						on
Clean & dry docking interface	yes			on	on	on					on		on
Continue drying	no				on	on	on				on		
Paint with green	no	on											

*Fig. 18*

Process sequence - refilling same color	Docked	Valve											
		A	B	C	D	E	F	G	H	I	J	K	L
Done painting red	no												
Clean inside & outside of bell	yes/no				on						on	on	on
Clean shroud	yes												
Prime lines with red	yes	on	on		on		on						on
Fill can with red	yes		on		on		on						on
Clean & dry docking interface	yes			on	on	on							on
Continue drying	no				on	on	on						on
Paint with red	no	on											

*Fig. 16*

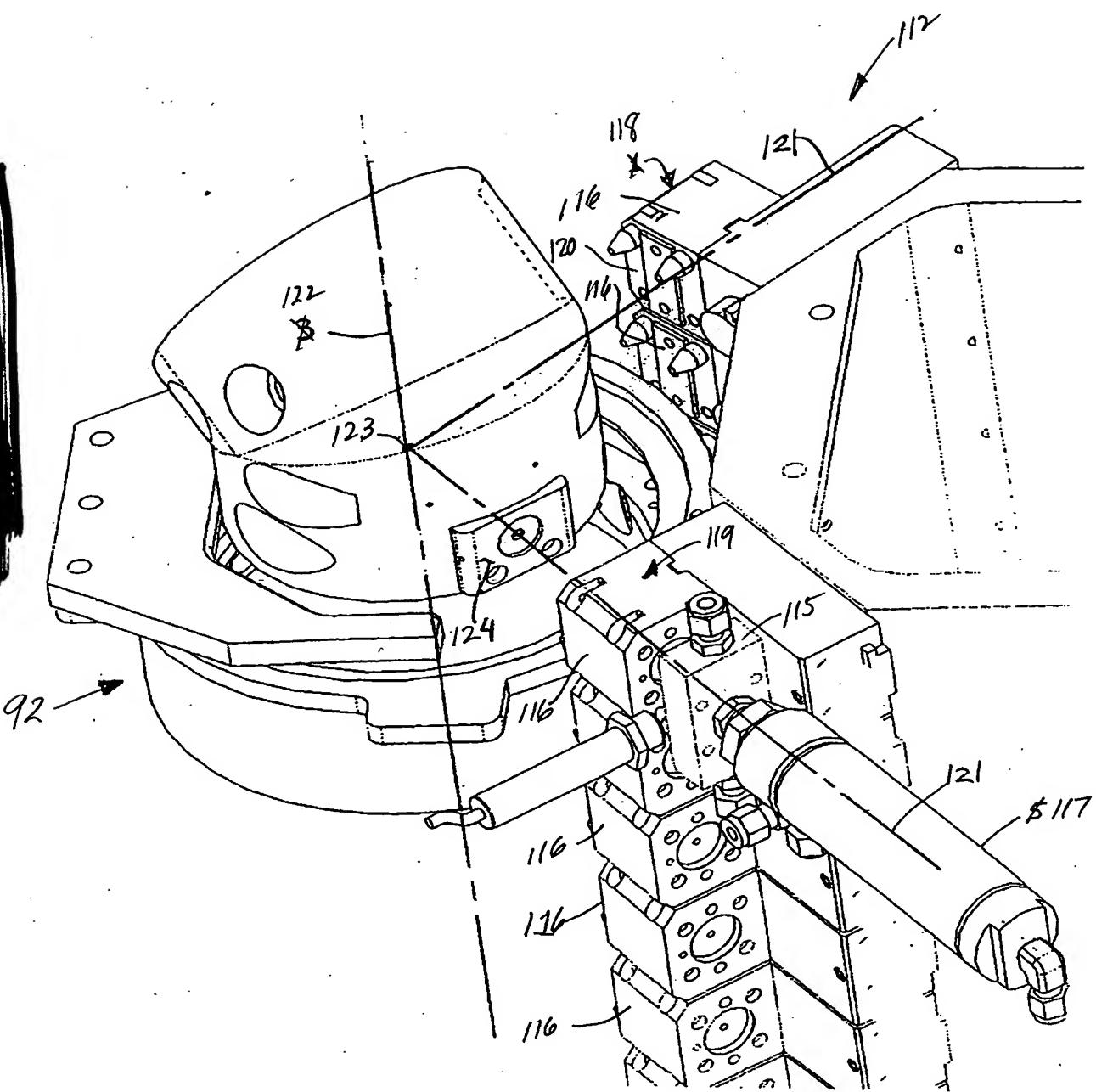


Fig. 19

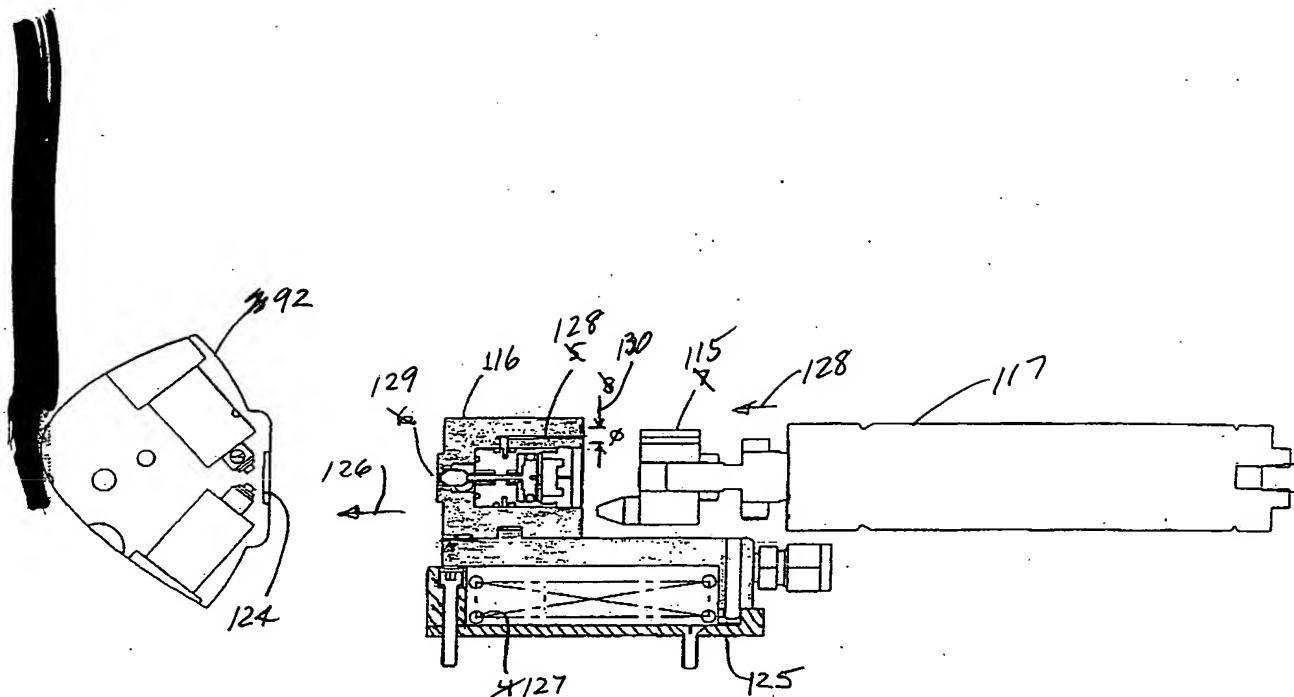


Fig. 20